

Date: Tuesday, 23/09/2008 10:22:10 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 42223

Estimate Number : 10283

P.O. Number :

This Issue : 23/09/2008

S.O. No. :

Prsht Rev. : NC

First Issue : / /

Type : SMALL /MED FAB

Previous Run : 40252

Written By :

Checked & Approved By :

Comment :

Est Rev:C Removed Scribing 05-11-05 JLM
 Est Rev:D As per Rev B 06-11-24 JLM

Drawing Name : BRACKET

Part Number : D31991

Drawing Number : D3199 REV B

Project Number : N/A

Drawing Revision : B

Material :

Due Date : 20/10/2008

Qty: 320 Um: Each

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description :

1.0

M304S20GA

304/316 .040 Sheet

Comment: Qty.: 0 sf(s)/Unit Total: 33 sf(s)
 304/316 0.040" SHEET

Batch: 109088

IB 8-9-24

2.0

WATER JET

FLOW WATER JET

Comment: FLOW WATER JET

Cut as per Dwg D3199

Dwg Rev: S

Prog Rev: B

IB 8-9-24

Deburr if required

IB 8-9-24

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
 Form as per dwg D3199

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 42223

Part Number: D31991

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

08/12/05 (190)

7.0

POWDER COATING

POWDER COATING



M 109 648



(190X)

Comment: POWDER COATING

POWDER COATING

Powder Coat Gey Sandtex (Ref. 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:50
320 °C
4:20

M-1 08/12/08

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-12-08

(190x)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

P-112/9 (190)

10.0

QC21

FINAL INSPECTION W/O RELEASE



08/12/08

Comment: FINAL INSPECTION W/O RELEASE

Job Completion



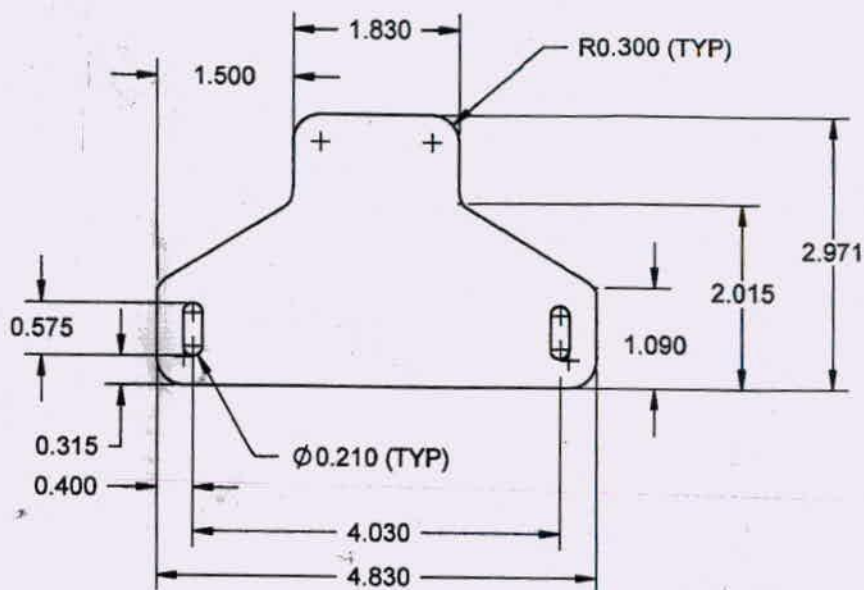
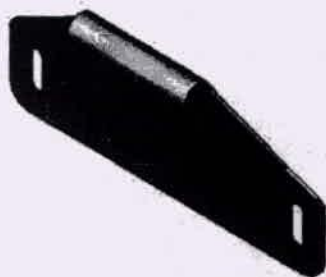
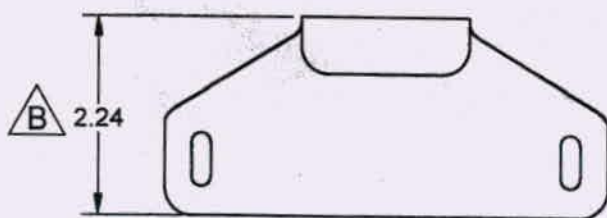
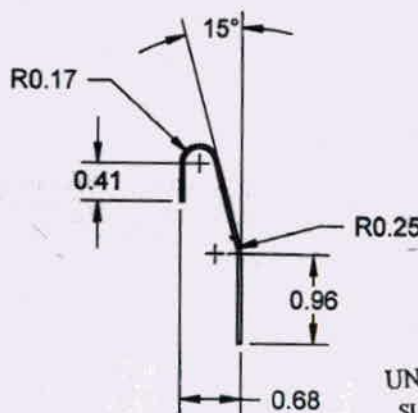
M-1 08-12-08

DART

DESIGN QP	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D3199	REV. B SHEET 1 OF 1
DATE 06.11.01	TITLE BRACKET		SCALE 1:2
REV	DATE	DESCRIPTION	
A	03.08.05	NEW ISSUE	
B	06.11.01	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	

RELEASED

06.11.20

**D3199-1 FLAT PATTERN****D3199-1 BRACKET**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42223

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) ANNEALED
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) AS PER QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3199-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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